Each

50 Um:

: MOUNTING LUG

: D22301

: N/A

: F

. D2230 REV F

: 19/05/2009

User:

Tuesday, 12/05/2009 1:03:17 PM

Melanie Fauteux

**Process Sheet** 

**Drawing Name** 

Part Number

Material

**Due Date** 

**Drawing Number** 

**Project Number** 

**Drawing Revision** 

Customer Job Number : CU-DAR001 Dart Helicopters Services

S.O. No. :

: 47912

: 10255 **Estimate Number** 

P.O. Number

This Issue

: 12/05/2009

: NC

Prsht Rev. : // First Issue

**Previous Run** 

: 47911 Written By

Checked & Approved By

Comment

: Est D 00.11.01

Type

Added inspection level 8, and removed P/O for

: MACHINED PARTS

powder coat

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

**Description:** Lug Extrusion

D2423 1.0

Comment: Qty.:

0.0717 f(s)/Unit

Total:

3.5858 f(s)

Lug Extrusion D2423 Extrusion

Batch: <u>R43726</u>

BAND SAW

BAND SAW

2.0

Comment: BAND SAW

Cut D2423 extrusion to 0.82"

Batch: 12 43722

D22301P

1.0000 Each(s)/Unit

Total:

50.0000 Each(s)

Comment: Qty.: LUG

HAAS1

4.0



HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2230-1

(Check for crack while loading into the machine.)

2-Tumble and deburr rough edges after tumbling



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W/O:			WO	RK ORDER CHANGI	ES					
DATE	STEP	PRO	CEDURE CHAI	IGE	Ву	D	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	-	,								
Part No	•	PAR #:	Fault Categ	jory:	NCR: Ye	es No	DQA	<b>\</b> :	Date:	
	R	lesolution:	Disposition	:	QA: N/C	Close	ed:		Date: _	
NCR:		V	VORK ORDE	R NON-CONFORMA	NCE (N	CR)		_ *- *		
DATE	STEP	Description of NC	<b></b>	Corrective Action Section			Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section		Chief Eng	QC inspector
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Tuesday, 12/05/2009 1:03:17 PM Date: User: Melanie Fauteux **Process Sheet Drawing Name: MOUNTING LUG** Customer: CU-DAR001 Dart Helicopters Services Part Number: D22301 Job Number: 47912 Job Number: Description: Seq. #: **Machine Or Operation:** INSPECT PARTS AS THEY COME OFF MACHINE 5.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 6.0 QC8 Comment: SECOND CHECK HAND FINISHING RESOURCE #1 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 8.0 . QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION POWDER COATING POWDER COATING M111472 Comment: POWDER COATING Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3 8:20 pm START TIME: 320°F OVEN TEMPERATURE: FINISH TIME: QC3 10.0 Comment: INSPECT POWDER COAT PACKAGING RESOURCE # 11.0 **PACKAGING 1** Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FINAL INSPECTION/W/O RELEASE 12.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd	D	art	Aer	ost	ace	Ltd
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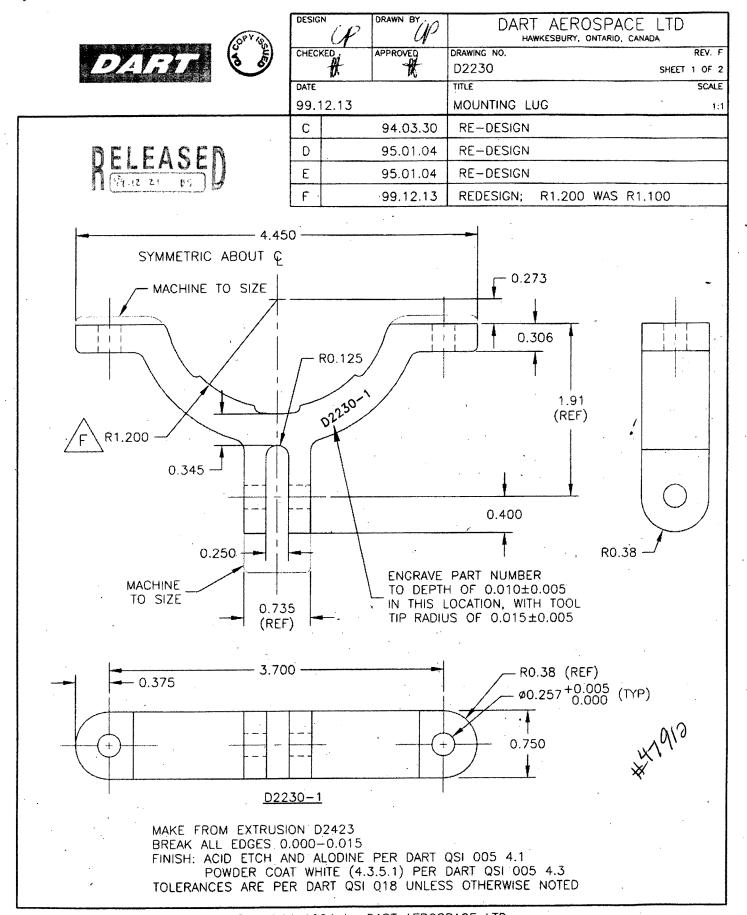
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Part No	) <b>:</b>	PAR #:	Fault Cate	gory:	NCR	: Yes N	o <b>DQ</b> A	\:	_ Date: _	
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DATE	OTED	Description of NC		Corrective Action Sec	tion B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	47912
Description: Mounting Lug	Part Number:	D2230-1
Inspection Dwg: D2230 Rev: F		Page 1 of 1

	FIRS	T ARTICLE II	NSPECTI	ON CHI	ECKLIST		
	X	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		Comments
4.450	+/-0.010	4.452	/				
0.306	+/-0.010	-308					·
0.345	+/-0.010	.350					
0.400	+/-0.010	.400					
0.250	+/-0.010	.255	/	-			<u> </u>
3.700	+/-0.010	3.698	/				
0.750	+/-0.010	751	/				
Ø0.257	+0.005/-0.000	.260	/				
1.91	+/-0.010	1.905	/				
R1.200	+/-0.010	1.207	/				
0.375	+/-0.010	.378	/				
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Measured by:	88,7	Audited by:	Onf		Prototype Ap	proval:	N/A
Date:	69/05/22	Date:	09/05/	25		Date:	
Rev Date	Change		<del>_</del>	· · · · · · · · · · · · · · · · · · ·		Revised	by Approved
A 03.11.11	New Issue					ت KJ/RF	<b>7</b> 1 14

## **Dart Aerospace Ltd**

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DATE	STEP	P	ROCEDURE CHANGE		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				:				
Part No	:	PAR #:	Fault Category:	NC	R: Yes N	o DQA:	_ Date: _	
NCR:				ON-CONFORMANCE			Date:	
DATE	STEP	Description of NC Section A	<del></del>	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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## **Dart Aerospace Ltd**

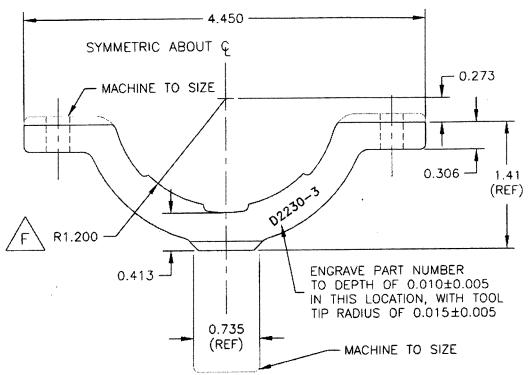
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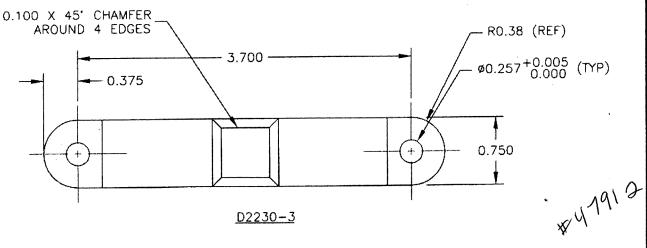




DESIGN	DRAWN BY		AEROSPACE LTE 5BURY, ONTARIO, CANADA	)
CHECKED	APPROVED	DRAWING NO.	SHEE	REV. F T 2 OF 2
DATE		TITLE		SCALE
99.12.13		MOUNTING LUG		1:1

## RELEASED





MAKE FROM EXTRUSION D2423 BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

## **Dart Aerospace Ltd**

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DATE	STEP	Description of NC		Corrective Action Section B			Verification	Approval	Approval
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